

Patent Claims

1. Method for producing products in web form in which a coating mass first is applied onto the surface of a transfer support web, subsequently the composite of transfer support web and coating is treated thermally, then an intermediate support material is applied on the coating and finally the composite of intermediate support layer and coating separated from the transfer support web, wound up and stored, wherein the transfer support web used is performed as an endless loop.
2. Method according to claim 1, wherein the transfer support web is comprised of a solid material such as polymer material or of a composite material of paper with a polymer layer on top or a metal foil or a composite material of metal and polymer film such as metallized polymer film.
3. Method according to claim 1, wherein the endless loop used as the transfer support web has a uniform thickness over its total length.
4. Method according to claim 1 wherein the coating is prepared by mixing its ingredients in an aqueous medium.
5. Method according to claim 1, wherein the coating is applied to the transfer support web in a coating station by a casting method or a reverse coating method in a thickness in the range of from 10 to 500 μm , preferably from 50 to 200 μm .
6. Method according to claim 1, wherein the transfer support web and the coating is thermally treated in a heating device.
7. Method according to claim 6, wherein the thermal treatment is performed in a hot air chamber at temperatures in the range of from 40 to 120 $^{\circ}\text{C}$.

8. Method according to claim 7 wherein the thermal treatment is performed at temperatures in the range of from 50 to 100 °C.
- 5 9. Method according to claim 1, wherein the thermally treated composite comprising the coating and the transfer support web are fed to a laminating- or cooling device, where an intermediate support material coming from a storage roll is applied onto the coating.
- 10 10. Method according to claim 1, wherein the intermediate support material is fixed with a strip of an adhesive at the starting point.
11. Method according to claim 1, wherein the intermediate support material is comprised of paper or paper like material like cardboard, or polymer film.
- 15 12. Method according to claim 1, wherein the separated transfer support web is fed to a regeneration station, wherein regeneration of the transfer support web is performed.
- 20 13. Method according to claim 12, wherein the regeneration of the transfer support web comprises at least mechanical removal of adhering foreign particles and vacuum cleaning of the mechanical treated transfer support web.
- 25 14. Method according to claim 13, wherein the regeneration is combined with a wet or chemical decontamination comprising washing the transfer film with clear water or organic solvent or cleaning it with detergents and drying it in hot air.
- 30 15. Method according to claim 1, wherein the regenerated transfer support web is immediately recirculated to the coating station, to be applied again with the coating.

16. Method according to claim 1, wherein the regenerated transfer support web is first wound up and after storage recirculated again to the coating station, to be applied again with the coating.

5 17. Device for performing the method for producing products in web form comprising at least a coating station (1), a laminating- or cooling station (3), separating rolls (4, 5, 6, 7) and a regeneration station (9) for a transfer support web, whereby the transfer support web is performed as an endless coil.

10 18. Device according to claim 17 comprising additionally a heating device (2) between the coating station (1) and the laminating- or cooling station (3).

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